

ASAP

Date: Thursday, 8/23/2007 11:53:26 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET	
Job Number	: 34243		Part Number	: D32641	
Estimate Number	: 11162		Drawing Number	: D3264 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	8/23/2007	S.O. No.	Type	: MACHINED PARTS	
Prsht Rev.	: NC		Drawing Revision	: A	
First Issue	: N/A		Material	: N/A	
Previous Run	: 33066		Due Date	: 9/3/2007	
Written By			Qty:	8.	
Checked & Approved By			Um:	/ Each	
Comment	: Est A 04.09.02		New issue	KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1250X04500	6061-T6 Bar 1.25" X 4.5" 
Comment: Qty.: 0.5097 f(s)/Unit Total : 3.0580 f(s) Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick (M6061T6B1.250x04.500) Identify for D3264-1 Batch: M105531 <i>DTP 07/12/18</i>		
2.0	BAND SAW	BAND SAW 
Comment: BAND SAW Cut blanks: 4.500" x 1.250" x 5.700" long Bar <i>DTP 07/12/18</i>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA447 and Dwg D3264 Identify as D3264-1 Deburr <i>DTP 07/12/18 / J.L.</i>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>J.L. 07/12/20</i>		
5.0	QC8	SECOND CHECK 
Comment: SECOND CHECK <i>SA 08/01/02 (X8)</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/01/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/20	3	1 part is crooked, crushed by vise R.C. Human error	BSI/01/02	Scrap + replace Qty 1 <u>BSI 105331</u>	BSI 01.02 08.01.02	08.01.02	BSI/01/02	BSI/01/02
..	3	1 part is too thin and holes are off by .020 R.C. Part was not flat on vise operation error	BSI/01/02	Scrap + replace Qty 1 <u>BSI 105331</u>	BSI 01.02 08.01.02	08.01.02	BSI/01/02	BSI/01/02
..	3	2 parts holes are off by .020 R.C. org in was off operator error	LE 08.01.02	Acceptable	LE 08.01.02	08.01.02	LE 08.01.02	LE 08.01.02

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	34243
Description: Bracket		Part Number:	D3264-1
Inspection Dwg: D3264	Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	0.6875	✓			
0.063	+/-0.010	0.062	✓			
0.125	+/-0.010	0.125	✓			
0.875	+/-0.010	0.875	✓			
0.062	+/-0.010	0.064	✓			
R0.03	+/-0.030	0.03	✓			
R0.13	+/-0.030	0.125	✓			
1.00	+/-0.030	1.006	✓			
0.125	+/-0.010	0.1265	✓			
0.600	+/-0.010	591	✓			
4.000	+/-0.005	4.000	✓			
0.750	+/-0.010	753	✓			
Ø0.194	+0.005/-0.000	1.96	✓			
5.50	+/-0.030	5.501	✓			
0.125	+/-0.010	0.126	✓			
0.063	+/-0.010	0.066	✓			
R0.25	+/-0.030	0.250	✓			
4.27	+/-0.030	4.270	✓			
R0.30	+/-0.030	R0.300	✓			

Measured by:	DJP	Audited by:	SA	Prototype Approval:	N/A
Date:	07/12/19	Date:	01.12.20	Date:	N/A

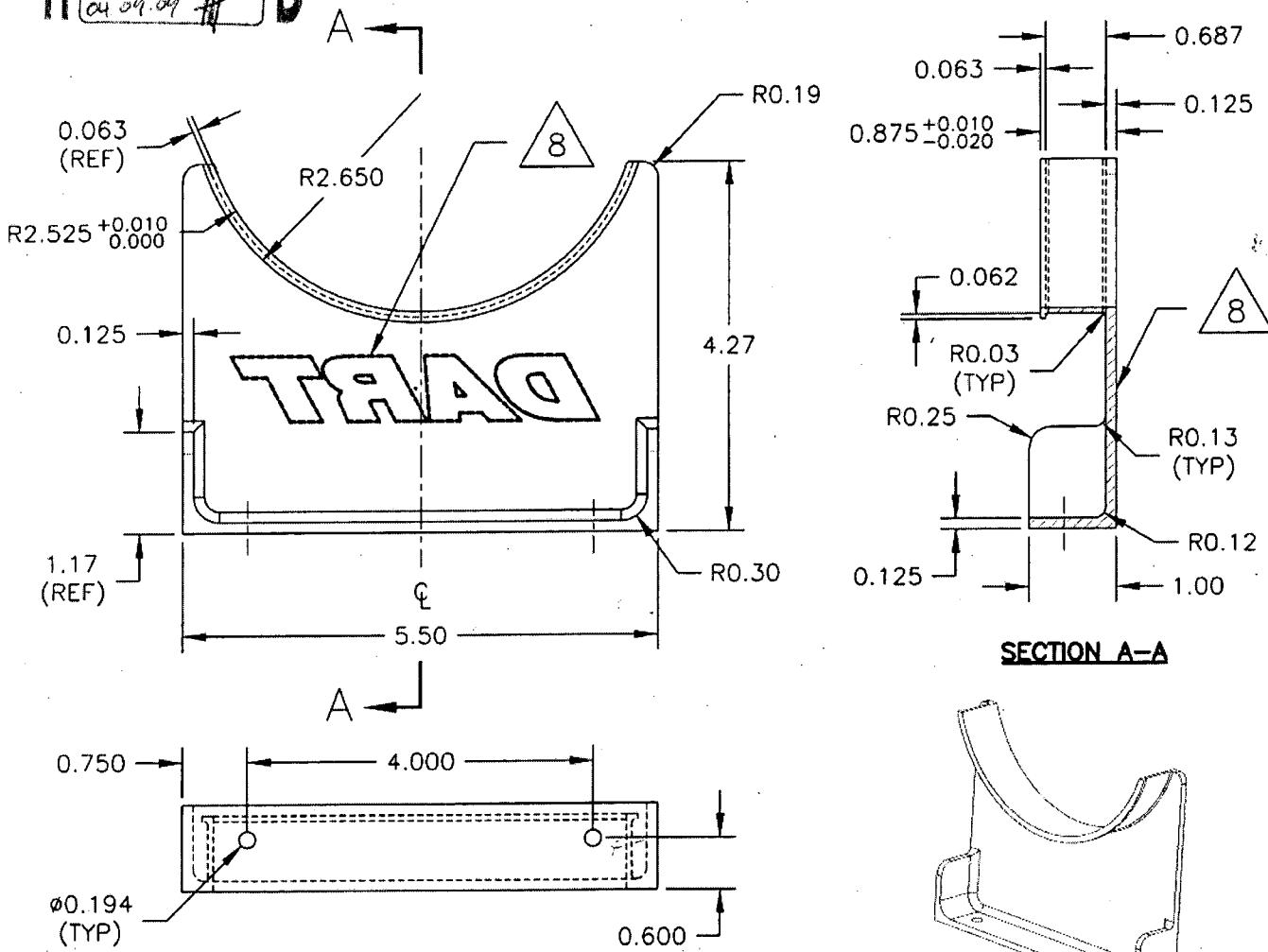
Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	20/04/2020

DART



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20		TITLE BRACKET	SCALE 1:2
A	04.04.20	NEW ISSUE	

RELEASED
04.04.09



D3264-1 BRACKET

D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC ENGRD 0016B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1.
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH
(MIN) TOOL RADIUS OF 0.25

0-503
D-503
SHOP COPY
RETURN TO
ENGRD 0016B
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34543